

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003999**Date Inspected:** 01-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to perform Ultrasonic Testing (UT) of Orthotropic Box Girder (OBG) components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Assembly Bay # 2

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector received notification from day shift task leader to perform conventional Ultrasonic (A scan) Inspection for tack welds on deck panels. The inspection is preliminary prior to using the phased array system to verify indications found with conventional Ultrasonic testing. This QA inspector performed UT on deck panel DP407-001, weld 1 scanned 18 locations with 0 indications, weld 2 scanned 18 locations with 0 indications, weld 3 scanned 18 locations with 0 indications, weld 4 scanned 18 locations with 0 indications, weld 5 scanned 18 locations with 1 indication, weld 6 scanned 18 locations with 1 indication, weld 7 scanned 17 locations with 1 indication, weld 8 scanned 18 locations with 0 indications, weld 9 scanned 18 locations with 0 indications and weld 10 scanned 18 locations with 4 indications. The QA inspector performed UT on deck panel DP324-002, weld 5 scanned 18 locations with 0 indications, weld 6 scanned 18 locations with 2 indications, weld 7 scanned 18 locations with 0 indications and weld 8 scanned 18 locations with 0 indications. Total tack welds inspected were 252 with 9 indications located in the area of interest (3.5 %). This QA inspector was informed by the task leader that a TL-6027 was not required at this time.

No other activities observed.

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Summary of Conversations:

Only general conversations between Caltrans QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann 150 0219 9593, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	Wright,Mark	QA Reviewer
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